



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

split

RB23007615-7
Job Sheet 196526-A



Part No: RB23007615-7

Job Qty: 16 pcs

Part Name: #27 Drill Bit

5214903



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/19/19

Job Tracking No:

Due Date: 9/28/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG RB23007615 REV B IPP REV A 18.02.20 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
144	QC 6	16 pcs	9/28/19		0.00	0.00	QC 6 - 9		
							QC 6 - 68		
							QC 6 - 61		
							QC 6 - 40		
146	Small Fab - 2 - B4B	16 pcs	9/28/19		0.00	0.80	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
148	QC 5	16 pcs	9/28/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
180	Packaging 3-1 - Stock - B4B	16 pcs	9/28/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		

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RB23007615-7
Job Sheet 196526



Part No: RB23007615-7

Job Qty: ~~21~~ **32 pcs.**

Part Name: #27 Drill Bit



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/14/19

Job Tracking No:

Due Date: 6/28/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RB23007615 REV B IPP REV A 18.02.20 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	SL-154 - 1	70 pcs		6/28/19	1.00	23.33	SL-154 - 1		JB 19-07-15
120	QC 2	70 pcs		6/28/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		JB 19-07-15
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

Dart Aerospace Ltd.
1270 Aberdeen St
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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com



Container No: S197737

Part: RB23007615-7

Job No: 196526

Serial No/Batch: S197737

Revision: B

Inspector:

Exp Date:

DAS
62
9-89

DAS
62
9-89

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6/14/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

130 QC 8	70 pcs	6/28/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	2mm L 14/07/15
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
140 Outsource - 4 - Anodize	70 pcs	6/28/19		ATG001-VC GR0002	HA 2019-07-17
142 Packaging 2-1 - Receive - B4B	70 pcs	6/28/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	DP JUL 22 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	

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				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
144 QC 6	70 pcs	6/28/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	DAS
				QC 6 - 61	61
				QC 6 - 40	9-89
146 Small Fab - 2 - B4B	70 pcs	6/28/19	0.00 3.50	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
148 QC 5	70 pcs	6/28/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	

6/14/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

180 Packaging 3-1 - Stock - B4B

70
pcs

6/28/19

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 -
B4BPackaging 3 - 11 -
B4BPackaging 3 - 12 -
B4BPackaging 3 - 13 -
B4BPackaging 3 - 14 -
B4BPackaging 3 - 15 -
B4BPackaging 3 - 16 -
B4BPackaging 3 - 17 -
B4BPackaging 3 - 18 -
B4BPackaging 3 - 19 -
B4BPackaging 3 - 20 -
B4BPackaging 3 - 21 -
B4BPackaging 3 - 22 -
B4BPackaging 3 - 23 -
B4BPackaging 3 - 24 -
B4BPackaging 3 - 25 -
B4BPackaging 3 - 26 -
B4BPackaging 3 - 27 -
B4BPackaging 3 - 28 -
B4BPackaging 3 - 29 -
B4BPackaging 3 - 30 -
B4BPackaging 3 - 31 -
B4BPackaging 3 - 32 -
B4BPackaging 3 - 33 -
B4BPackaging 3 - 34 -
B4BPackaging 3 - 35 -
B4BPackaging 3 - 36 -
B4B

190 QC 21 - SA

70

6/28/19

0.00 0.00

QC 21 - SA - 21

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pcs

QC 21 - SA - 70

QC 21 - SA - 53

Part Op 110 - (MORI SL-154 LATHE), 1-Machine (-2 block) as per folio FC030 FOLIO REV: AA DWG REV:
 Descriptions: 3 2- Debur

120 - (QC2- Inspect parts off machine FAI/FAIB), 1- Engrave drill sizes using Marktronic engraver as per DWG RB23007615 sheet #2.

130 - (QC8- Inspect parts - second check)

140 - (Outsource process-Anodize per QSI017 4.1.10.1), -Issue P/O; PO 44026 -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required

142 - (Receve & Inspect for Damage & Mat'l Certs)

144 - (QC6- All purchased or subcontracted products)

146 - 1- Assemble #27 drill bit into RB23007615-2 with Loctite clear multipurpose. -

148 - (QC5- Inspect part completeness to step on W/O)

180 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6H0.312	6061-T6 Hex Bar .312	6.3000 ft (.09 ea)	110-SL-154 - 1	<u>5162400</u>
AB51127	No. 27 Hs Taper Length	70 Ea (1 ea)	146-Small Fab - 2 - B4B	<u>2X519333</u> <u>3X519333</u> <u>7X5002</u> <u>2X519333</u> <u>1X5093431</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-SL-154 - 1	M6061T6H0.312	6	24	0
146-Small Fab - 2 - B4B	<u>AB51127</u>	70	13	0

Part Specifications

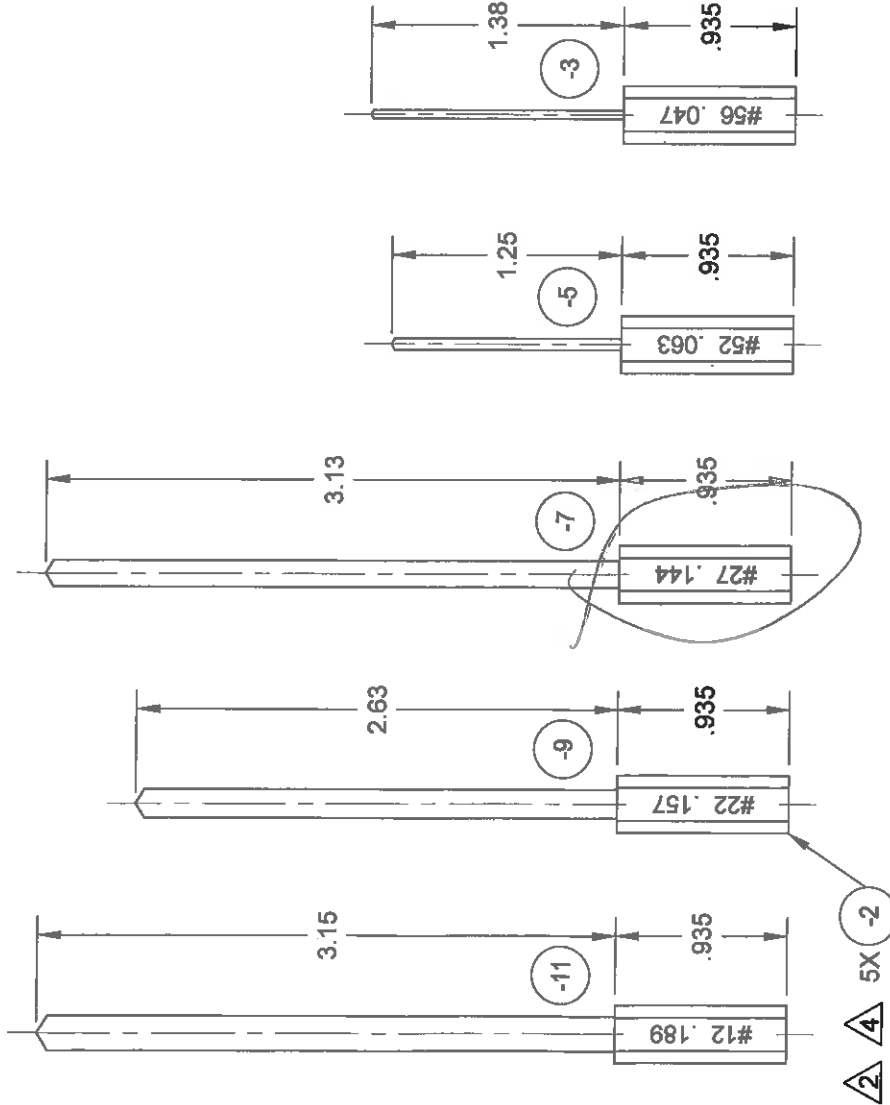
Specifications could not be found.

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REVISIONS		DESCRIPTION		DATE	INITIAL	APPROVED
REV	B	-2 ADDED NOTES TO SHEET.		2/3/14	DPD	RJC

TEO ATTACHED



NOTES:

1. CHECK EACH HOLE FOR PROPER EXPOSED DRILL LENGTH.
2. -2 TO BE DRILLED FOR BIT TO ACHIEVE EXPOSED DRILL LENGTH.
3. EPOXY BIT INTO -2 AFTER ANODIZING.
4. ANODIZE BLACK MIL-A-8625F, TYPE II, CLASS II

TITLE		DRAWN BY:		COLL	
POWER TURBINE CLEANING KIT		APPROVED		2/11/14	
DWG NO. RB23007615-2 THRU -11		REV		B	
UNLESS OTHERWISE SPECIFIED		DIMENSIONS ARE IN INCHES		DECIMALS	
TOLERANCES ON:		FRACTIONS ± 1/32		ANGLES ± 5°	
XX ± .005		XX ± .01		XX ± .1	
X ± .1		X ± .1		X ± .1	
UNLESS OTHERWISE SPECIFIED		1. BREAK ALL SHARP EDGES		.015 x 45° PR .015 R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		SCALE		1:1	
DATE		2-1-01		SHEET 2 of 7	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044026



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044026

PO Date: 7/17/19

Due Date: 7/25/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-07-18

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	197448	RBE350A93-3302-02-1	Handle (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2, Water sealant As Per Dwg RBE350A93- 3302-02-1 Rev. 11 -Certificate of Conformity is required	Firmed -		7/25/19	18 pcs	0 pcs	18 pcs	\$5.49/pcs	\$98.82
2	196526	RB23007615-7	#27 Drill Bit (Outsource process- Anodize per QSI017 4.1.10.1), -Issue PO -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed -		7/25/19	32 pcs	0 pcs	32 pcs	\$1.25/pcs	\$40.00
Grand Total:											\$138.82



Dart Aerospace Ltd.
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Canada

Tel (813) 632-5200

PURCHASE ORDER

POHB044026



Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/18/19 9:29 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(020839-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

020839 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No	Bon de commande Client Customer Purchase Order No.				
19-Jul-2019		Jigar Patel		POHB044026				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE350A93-3302-02-1 Rev.	RBE350A93-3302-02-1 ANODIZE BLACK AS PER IAW MIL-A-8625F TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	18	18	0	0	0
2	RB23007615-7 Rev.	RB23007615-7 ANODIZE COLOR BLACK AS PER IAW MIL-A-8625F TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	32	32	0	0	0

RECEIVED

JUL 19 2019

DART AEROSPACE LTD.

DAS
61
9-89

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

JP JAY

Notus certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.